

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-006653**Date Inspected:** 07-May-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen Xi**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG crossbeams**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Steve Hall was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

**OBG cross beam CB1**

This QA noted that the contractor does not appear to have repaired the cracked CJP welds discovered on 05/06/09. The welds are identified as SP215-001-048 and FB206-001-028. This QA continued random Visual Testing (VT) on this crossbeam. This QA observed no significant weld or base metal discontinuities. No other significant work was being performed on this crossbeam during the time this QA was present.

**OBG cross beam CB2**

This QA noted that this crossbeam has been set into the superstructure assembly. This QA performed random Visual Testing (VT) on this crossbeam. This QA observed no significant weld or base metal discontinuities. No other significant work was observed on this cross beam during the time this QA was present.

**OBG cross beam CB3**

This QA observed that this crossbeam is still in the paint bay. This QA observed several of the contractors

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# WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

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personnel touching up the paint. No other significant work was being performed on this crossbeam during the time QA was present.

## OBG cross beam CB4

This QA observed the contractors Quality Control (QC) personnel performing Visual Testing (VT) after welding. No other significant work was being performed on this crossbeam during the time QA was present.

## OBG cross beam CB5

This QA observed ZPMC qualified welding personnel identified as 055564 and 037705 welding temporary lifting lugs at the corners of this crossbeam using the FCAW process. ZPMC QC identified as Mr. Zhang Yaxu was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2233-TC-U4b-F.

## OBG cross beam CB6

This QA observed That ZPMC personnel are fitting and tack welding the bottom panel to the side and intermediate panels on this crossbeam. No other significant work was being performed on this crossbeam during the time QA was present.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



## Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (15000422372), who represents the Office of Structural Materials for your project.

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## WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

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<b>Inspected By:</b>	Hall,Steven	Quality Assurance Inspector
<b>Reviewed By:</b>	Prue,Erik	QA Reviewer

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